

Work Order ID 162264

Wednesday, May 31, 2017 9:50:48 AM

162264

Page 1

Item ID: D2282-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Assembly
 Start Date: 6/7/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/27/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: PA **DAS 21 9-89** Date: 20170531 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								
100		0.00							
100	Large Fab								
Large Fab	Memo	2.00							
Large Fab	1-Weld as per D2282-043 Saddle Assembly A/RER316L SS Filling Rod <u>M13GS</u> Dwg Rev: <u>E</u>								
110		0.00							
110	Small Fab								
Small Fab	Memo	0.39							
Small Fab	1- Grind weld with rough pad and brown pad, take all welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***								
120		0.00							
120	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.20							
Quality Control									

10 Q.L 17-06-05

10 Q.L 17-06-05

(15) 17-06-07 **DAS 9 9-89**

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Small Fab	Memo	1.00							DAS 9 9-89
Small Fab	1 - Turnle								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.20							(15) 170607 DAS 9 9-89
Quality Control									
160	Identify as per dwg & Stock Location GA	0.00							
160									
Packaging	Memo	0.20							
Packaging	LOCATION : GA								10 $\emptyset$ JUN 07 2017 DAS 19 9-89

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	1.00							
Quality Control									

17/6/12 

 JUN 07 2017

Picklist Print

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Work Order ID: 162264

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Parent Item: D2282-043

D2282-043

Parent Item Name: Saddle Assembly

Start Date: 6/7/2017

Required Date: 6/27/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2281

Manufactured

No

100

Each

55.0000

1

10

D2281

**

Q.L

17-06-05

Jack Saddle

Location

Loc Qty

Loc Code

WA001

55

150910

0

160570

55

10

D2282-7

Manufactured

No

100

Each

95.0000

2

20

D2282-7

**

Q.L

17-06-05

Tube

Location

Loc Qty

Loc Code

WA001

95

160573

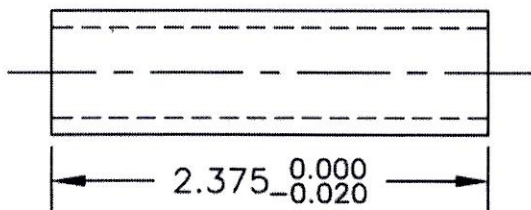
95

20

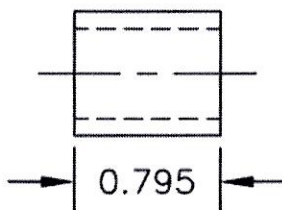


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1	
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

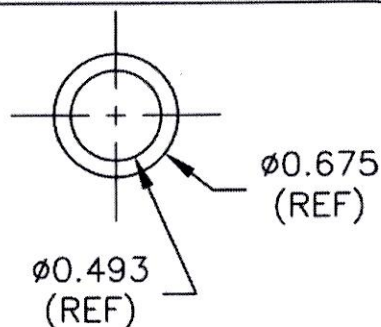
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05/09/16



D2282-3

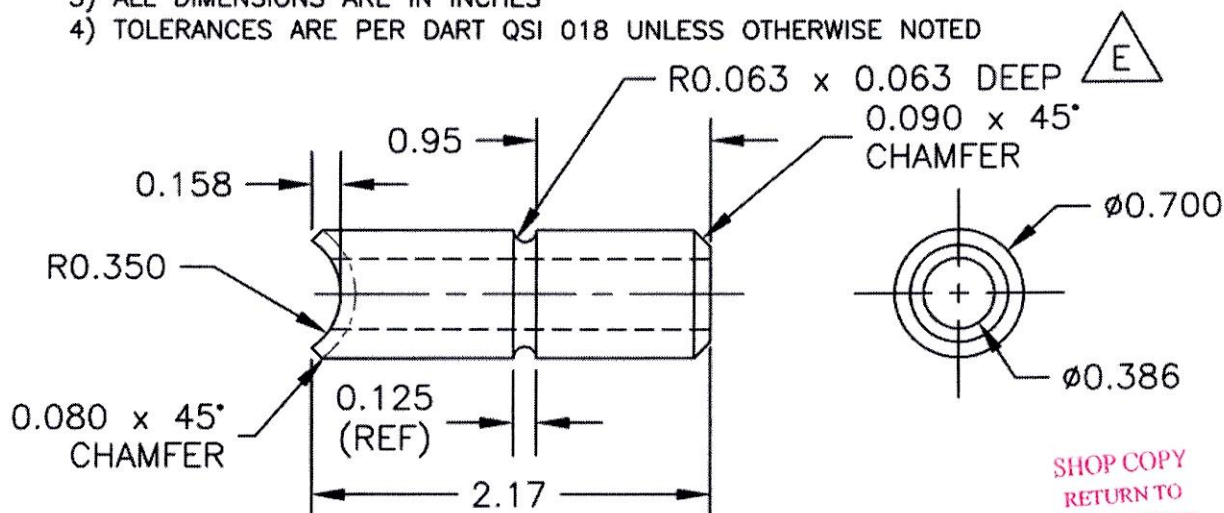


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *122268*

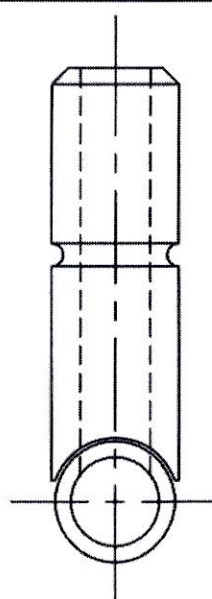
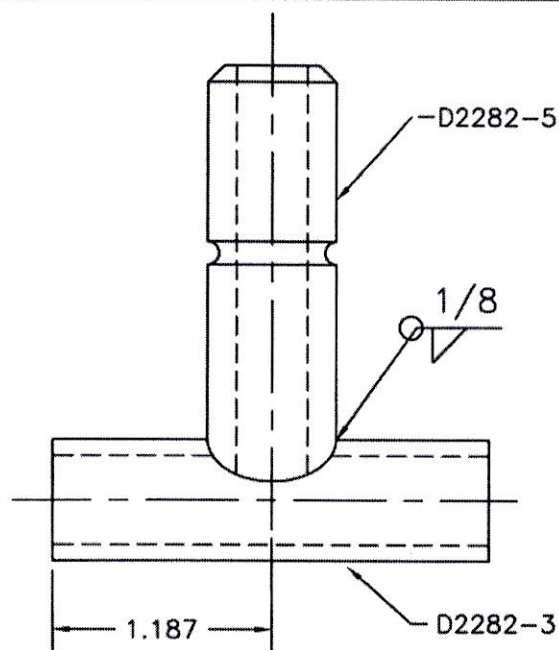
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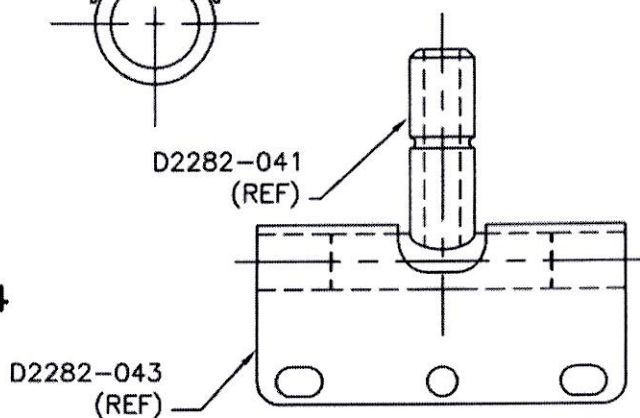


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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

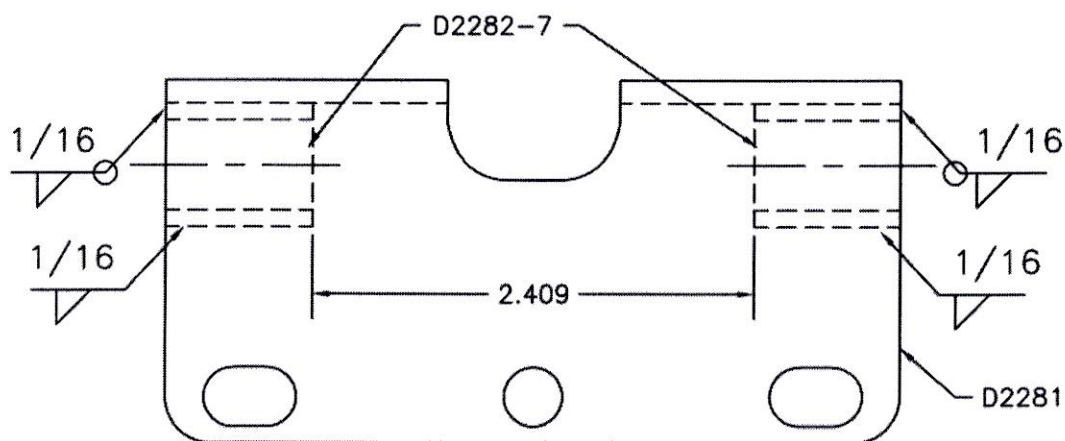


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05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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